Work Order ID 57556

April 8, 2010 10:03:36 AM

Item ID: D2939-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Saddle LH In, 206

Start Date: 4/08/10 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 4/16/10 **Req'd Qty:** 4.00 **Customer:**

Reference: 10.04.08 **Run Start** **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2939	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00				4	Ø		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program part number and batch number.☐1-Inspect part number and batch number are programmed correctly.☐2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐3-Machine Step No 2 of Folio and visually inspect as per								
110	CONVENTIONAL MILLING MACHINE	0.00				4	Ø		
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet					1			
120	QC1- Inspect dimensions to dimension sheet	0.00				4	Ø		
QC	**Memo**	0.00							
Quality Control									

B.A 10/04/11

B.A 10/04/15

B.A 10/04/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 57556

April 8, 2010 10:03:36 AM

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				4	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				X4	0		
150 Powdercoat Powder Coating	White Gloss(Ref:4.3,5.1) per QSI005 4.3-Alum M114207 Memo START TIME: 10:15am ☐OVEN TEMPERATURE: 10:45am ☐FINISH TIME: 320°F	0.00 0.00				X4	0		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 57556

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				(4)		BR	10-4-19
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 428A	0.00							
Packaging	**Memo**	0.00							10/4/20
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							10/04/20
Quality Control									MF 10-4-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

April 8, 2010 10:03:35 AM

Work Order ID: 57556

Parent Item: D2939-1

Parent Item Name: Saddle LH In, 206

Start Date: 4/08/10 **Required Date:** 4/16/10

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC
IPP Rev:C As per Rev C 07-03-19 JLM □□

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	86.0000	4.0000			

Saddle Billet

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	40	
46409	40	
Main Warehouse		
MAT40	46	
46409	46	

4.0 Y.A 10/04/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	57556.
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.128	0.127	0.128	0.128		
B	0.100	0.140		0.128	0.127	0.128	0.128		
C	0.100	0.140		0.123	0.118	0.123	0.122		
D	0.210	0.230		0.226	0.225	0.225	0.215		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.260	0.260	0.260	0.260		
L	0.312	0.317		0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.240	0.237	0.238		
N	0.100	0.140		0.110	0.110	0.110	0.110		
O	0.540	0.560		0.548	0.548	0.548	0.548		
P	0.490	0.510		0.500	0.501	0.501	0.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.738	2.738	2.738	2.738		
S	0.240	0.270		0.255	0.255	0.255	0.244		
T	0.100	0.180		0.125	0.125	0.125	0.125		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.262	1.262	1.263		
Y	1.565	1.585	DT8695 A/B	1.577	1.579	1.579	1.580		
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	K.A
Date:	10/04/11

Audited by	
Date:	2021/04/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

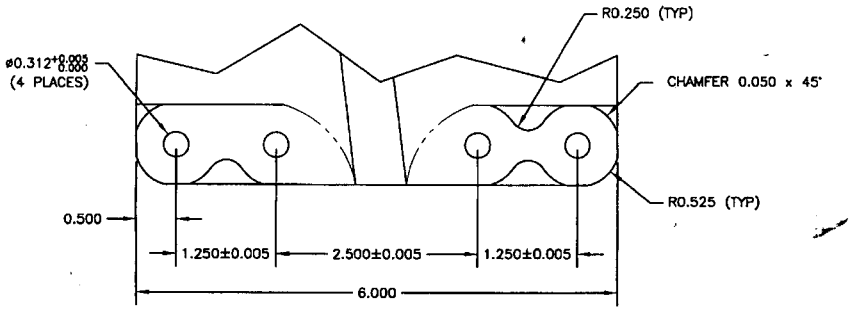
EAGLE
COPTERS MAINTENANCE LTD.

The value adding parts of the process are obvious, so companies mistakenly focus on trying to make them go faster. The waste is not obvious, so it is not addressed. Lean focuses on eliminating the waste.

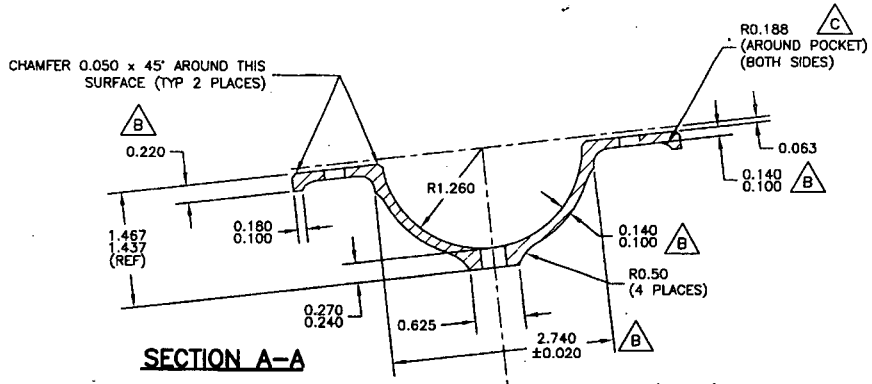
Lean is ongoing, there is no end to the search for

waste!

w/o 57556.

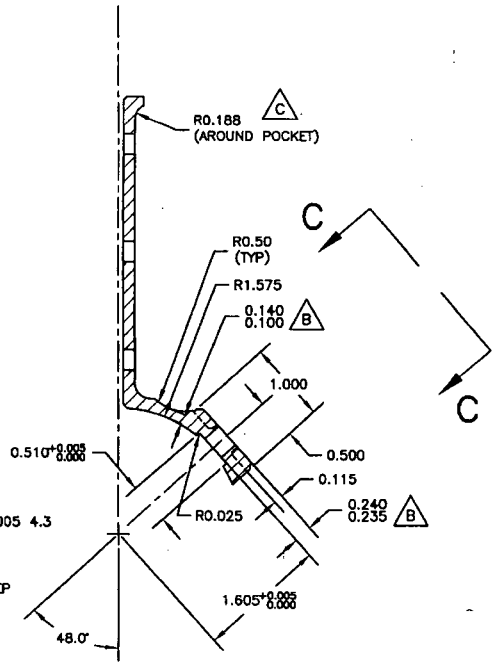


VIEW C–C

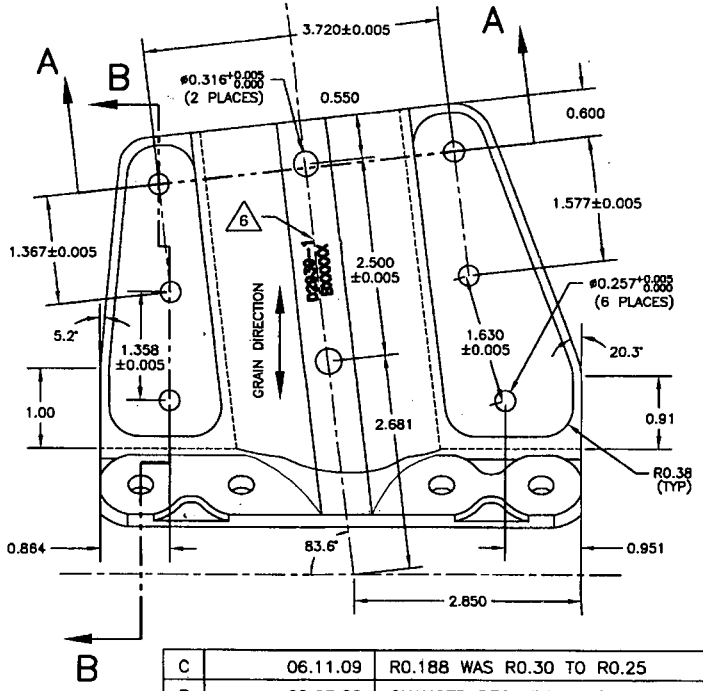


SECTION A–A

D2939–1 LH SADDLE (SHOWN)
D2939–2 RH SADDLE (OPPOSITE)



SECTION B–B



NOTES:
1) MATERIAL: ALUMINUM 7075–T7351 (QQ–A–250/12)
(MAKE FROM D6101–001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

07.02.12

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

DESIGN	DRAWN BY CB	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED PH	APPROVED	DRAWING NO. D2939	REV. C SHEET 1 OF 1
DATE 06.11.09		TITLE SADDLE INSIDE	SCALE 2:3

EAGLE
COPTERS MAINTENANCE LTD.

7 deadly wastes

1. Overproduction

2. Rework

3. Transportation

4. Inappropriate / over Processing

5. Unnecessary Inventory

6. Delays / Waiting

7. Unnecessary Motions